

Work Order ID 63570

Thursday, November 04, 2010 1:13:31 PM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

BP

Date: *10-11-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

B10-11-16

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☒ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B10-11-16

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/10/16

(12)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Thursday, November 04, 2010 1:13:31 PM

Page 2

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Accept

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Required Date: 11/12/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *FR11*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/17 *(12x)**10/11/17*
10-11-17
(12)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, November 04, 2010 1:13:35 PM

Page 1

Work Order ID: 63570

Parent Item: D3536-23

Parent Item Name: Gasket




Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063  NEOPRENE SHEET 0.063		Purchased	No			100	sf	495.6220	1.3365	17.82			



18 10-11-16

Location

Loc Qty

Loc Code

MAT

495.622

115500

95.622

115916

400

115916

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	63576
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	✓		T 1301	
48.20	+/-0.030	48.20	✓		T	
44.70	+/-0.030	44.70	✓		T	
39.31	+/-0.030	39.31	✓		T	
33.92	+/-0.030	33.92	✓		T	
28.53	+/-0.030	28.53	✓		T	
23.14	+/-0.030	23.14	✓		T	
17.75	+/-0.030	17.75	✓		T	
14.25	+/-0.030	14.25	✓		T	
9.50	+/-0.030	9.50	✓		T	
4.75	+/-0.030	4.75	✓		T	
8.00	+/-0.030	8.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
24.00	+/-0.030	24.00	✓		T	
32.00	+/-0.030	32.00	✓		T	
39.00	+/-0.030	39.00	✓		T	
48.00	+/-0.030	48.00	✓		T	
0.30	+/-0.030	0.30	✓		V 1302	
0.30	+/-0.030	0.30	✓		V	
1.89	+/-0.030	1.895	✓		V	
Ø0.19	+0.005/-0.001	0.190	✓		✓	

Measured by:	RB
Date:	10-11-16

Audited by:	8
Date:	10/11/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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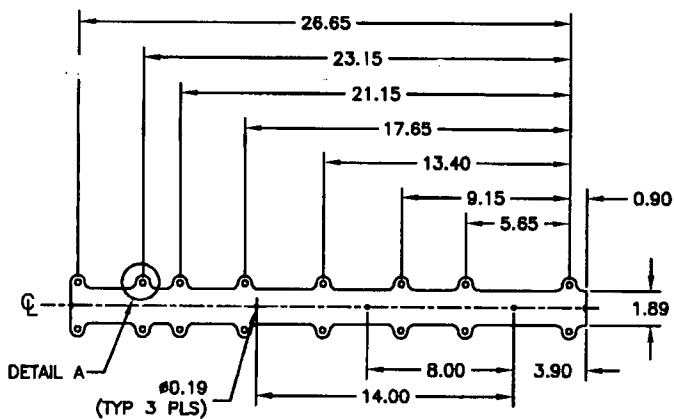
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DART

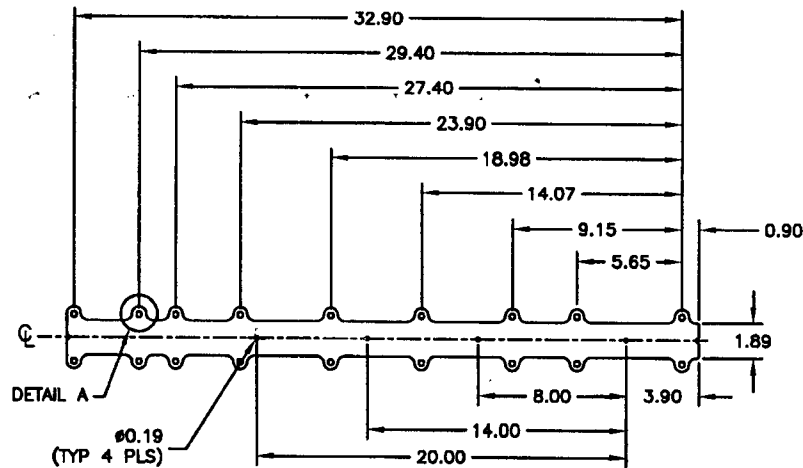
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09.02.12-11

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63570
B/10-11-04



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 1 OF 6
A	06.10.25	SCALE
	NEW ISSUE	1:10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

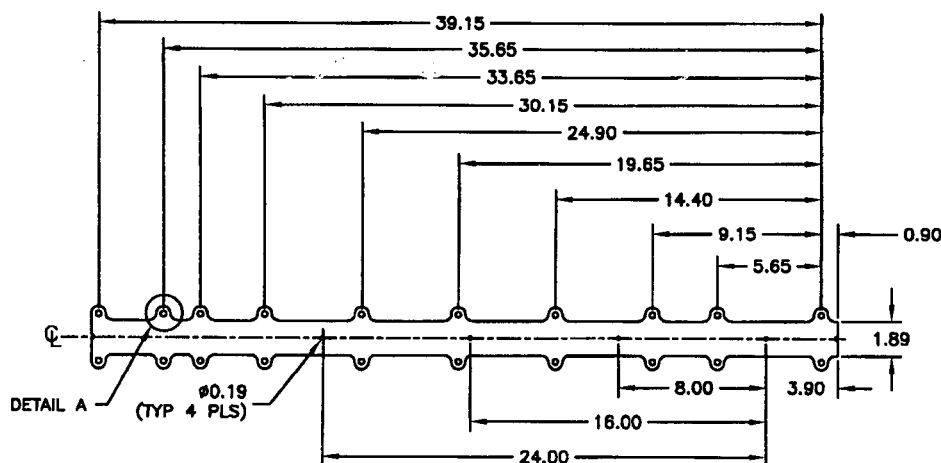
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DART

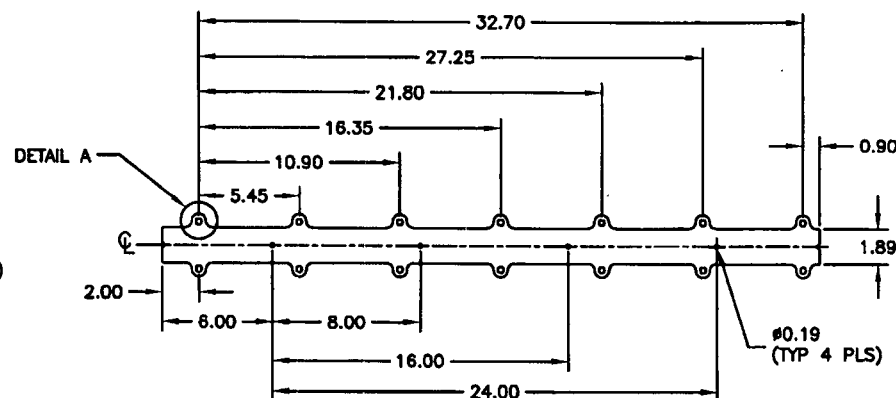
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CHECKED	AM	APPROVED	AM	PORT HADLOCK, WA	
DATE	06.10.25	DRAWING NO.	D3536	GASKET	SHEET 2 OF 6
		TITLE	GASKET	SCALE	1:10

RELEASED
07.02.12



D3536-15 GASKET

W/ 43570



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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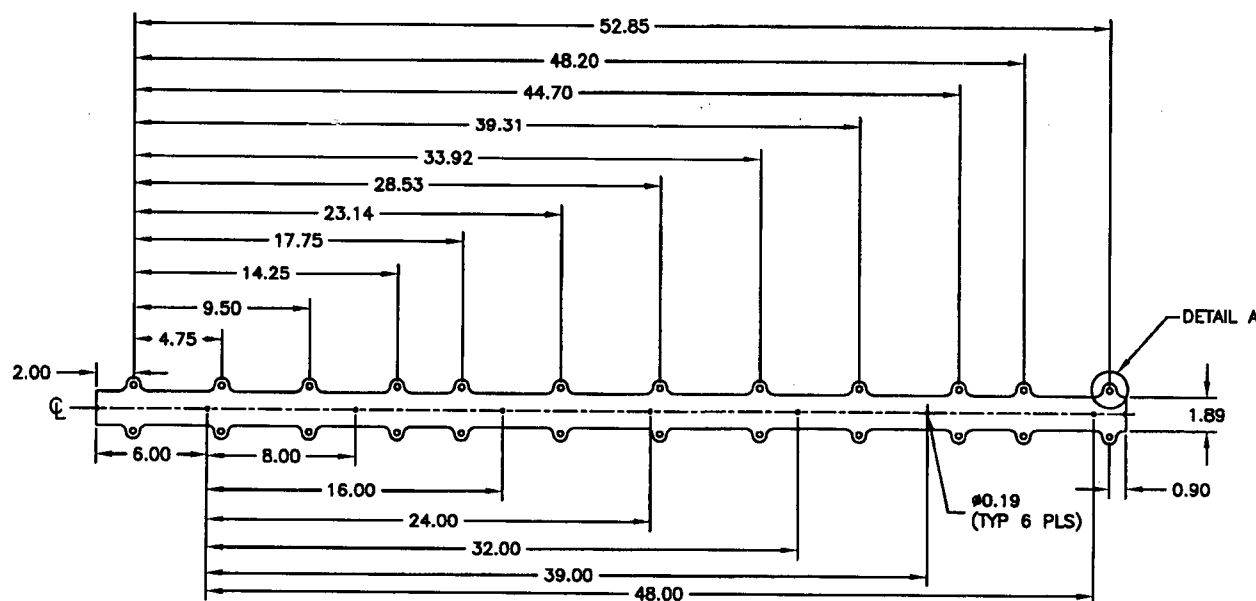
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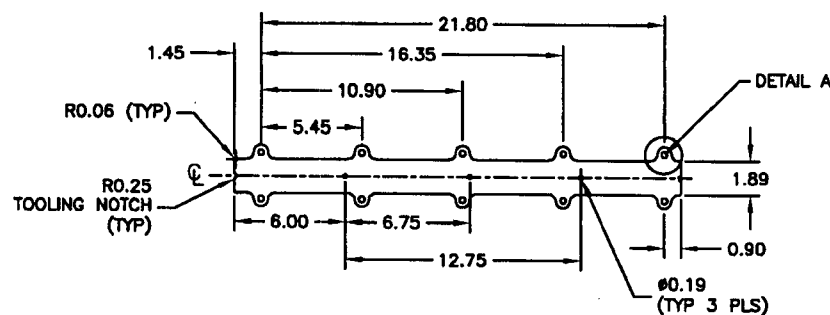
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CB	CB	PORT HADLOCK, WA		
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A	
DATE 06.10.25		TITLE GASKET	SHEET 3 OF 6	SCALE 1:10

RELEASED
07.02.12
PH



D3536-23 GASKET

w/43570



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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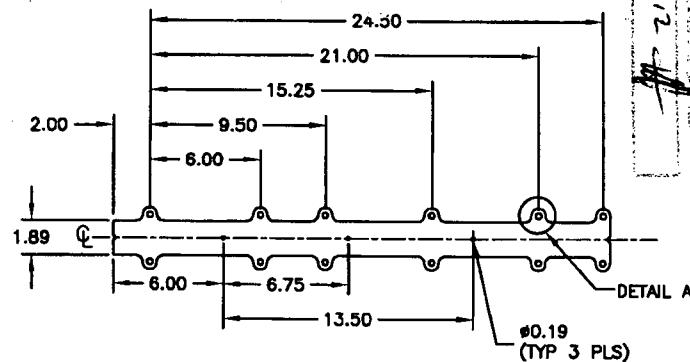
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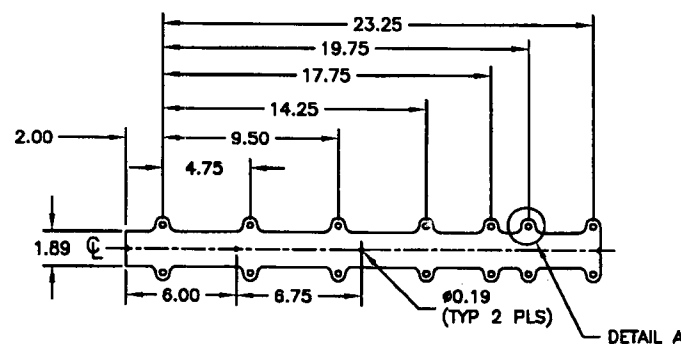
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
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				SCALE
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07.02.12

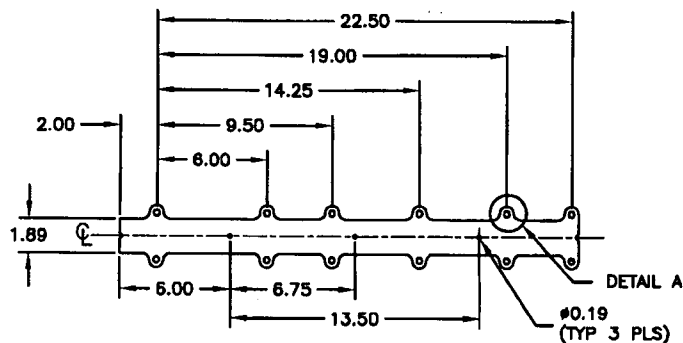


D3536-33 GASKET

w/ 43570



D3536-35 GASKET



D3536-31 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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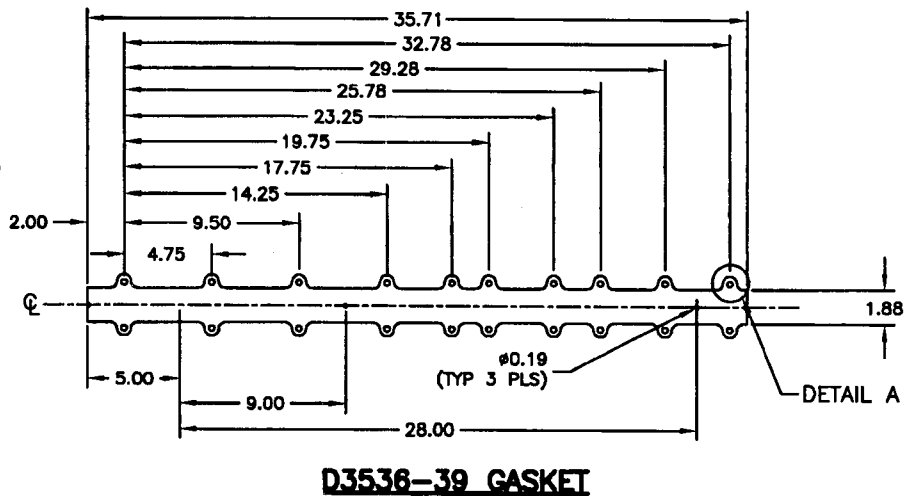
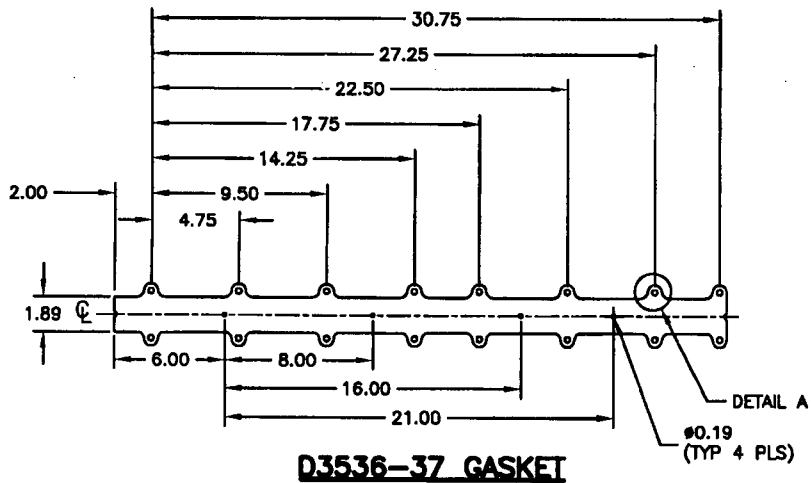
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
				SCALE 1:10

06.10.25
PH

u10 43570



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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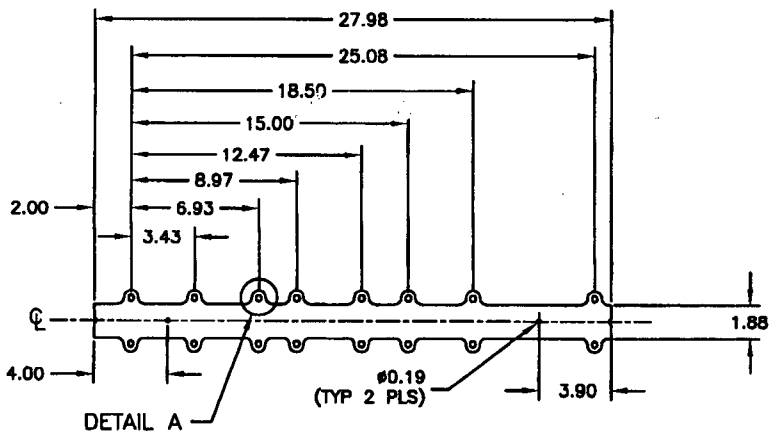
NOTE: Date & initial all entries

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CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10

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07.02.12 **CB**

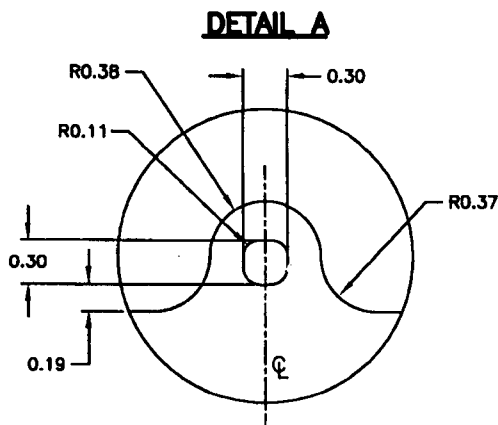
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D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.083)
- 2) FINISH: NONE
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